

Date: Tuesday, 11/13/2007 1:33:32 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
 Job Number : 35690
 Estimate Number : 11066
 P.O. Number : *N/A* Part Number : D2945
 This Issue : 11/13/2007 S.O. No. : *N/A* Drawing Number : D2945REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : A
 Previous Run : 29914 Material : *N/A*
 Due Date : 11/20/2007 Qty: *22* Um: *20* Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est B 00.01.27 Added inspect level 8, removed P/O for powder coating EC
 Est Rev:C Now on Waterjet 06-12-13 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0187X04000 6061-T6 Bar .178" x 4.0"



5.9667



Comment: Qty.: 0.2712 f(s)/Unit Total : 5.4243 f(s)
 6061-T6 Bar .178" x 4.0"
 Material: 6061-T6 (QQ-A-250/11)4.00" x 0.188" thick
 Batch No. *10544* *IB 07-11-14*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2945
 Dwg Rev: *A*
 Prog Rev: *A*

IB 07-11-14



2-Deburr if necessary

[Signature] *04/11/19* *(22)*

8B

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 07-11-14



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

[Signature] *04/11/20* *(22)* *counts*

5.0 HAND FINISHING#1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Acid etch and Alodine as per QSI 005 4.1

HS *04-11-20* *(x22)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 07/11/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG

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Part Number: D2945

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/20 (22)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL 07/11-20

(22)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5754

07/11/21 (22)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/20

Job Completion



07/11/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

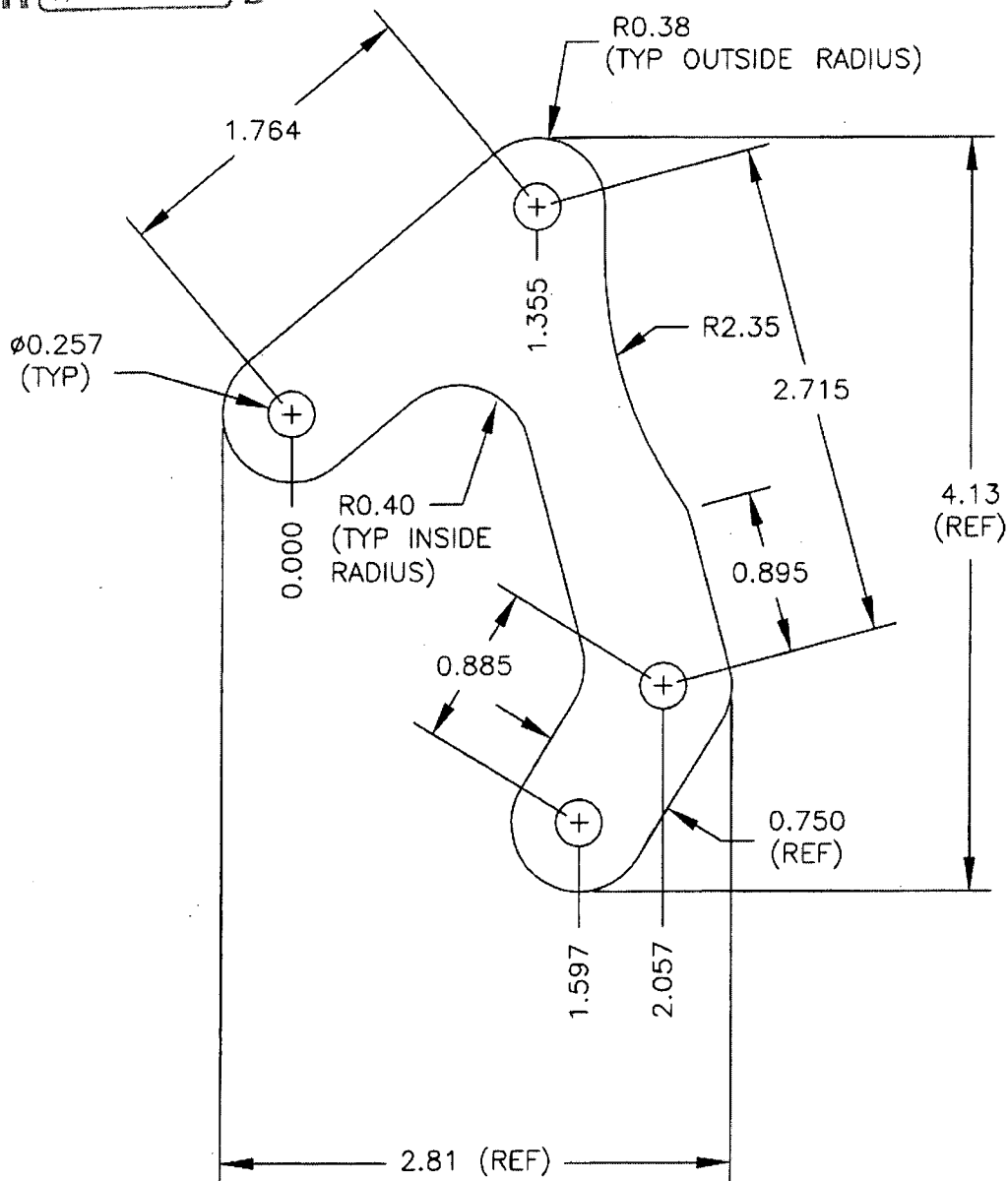
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2945	REV. A SHEET 1 OF 1
DATE 99.12.13		TITLE STEP MOUNTING PLATE	SCALE 1:1
A	99.12.13	NEW ISSUE	

RELEASED
99.12.21 DS



MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 35690